

Date: Thursday, 3/23/2006 3:44:54 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOOR PROTCTOR AFT RH		
Job Number	: 26356					
Estimate Number	: 11235					
P.O. Number	: N/A			Part Number	: D32814	
This Issue	: 3/23/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D3281 REV B	
First Issue	: N/A		Type	: PURCHASED PARTS		
Previous Run	: 25123			Project Number	: N/A	
Written By	: SEE COMMENT BELOW			Drawing Revision	: B	
Checked & Approved By	: KJ 06.03.24			Material	: N/A	
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM			Due Date	: 4/10/2006	
				Qty:	20	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>0000889</u> <i>sl</i> <u>06/03/28</u>	
		Description: Floor Protector Aft RH Possible Supplier: Delastek Certificate of Conformity is required	
2.0	D32814P	Floor Protector, Aft RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Floor Protector, RH	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached	<i>Rec'd 4/11/17 20</i>
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.	<i>4/11/17 20</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<i>4/11/18 20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:44:54 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR AFT RH

Job Number: 26356

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(initials) 06/04/19

Job Completion



W 0604.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

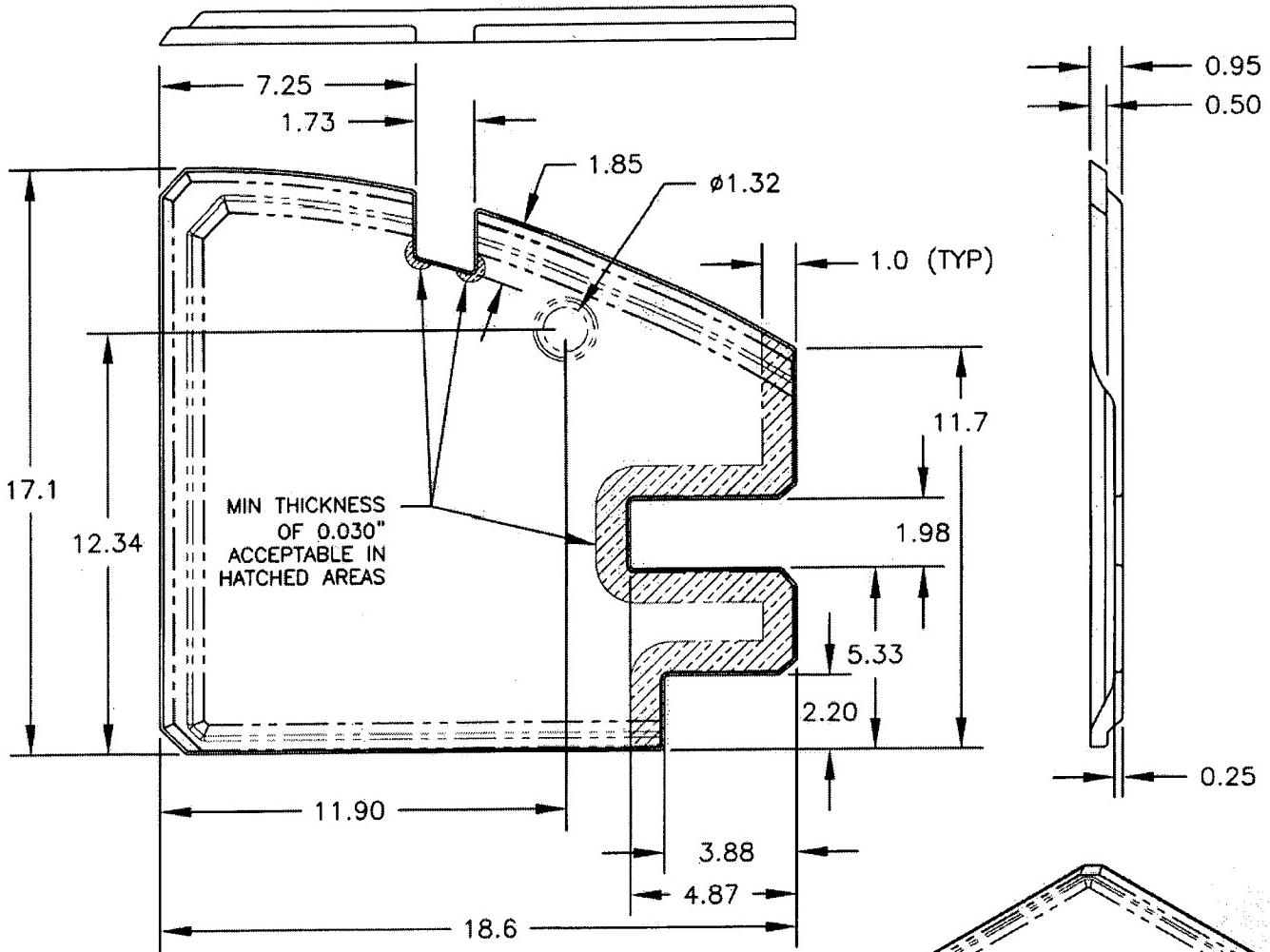
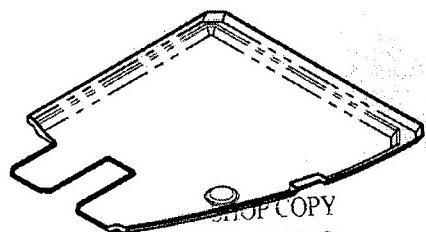
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3281	SHEET 1 OF 3
DATE		TITLE	SCALE
05.11.25		FLOOR PROTECTOR	1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**RELEASED**
05.12.01**D3281-1 FLOOR PROTECTOR. FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

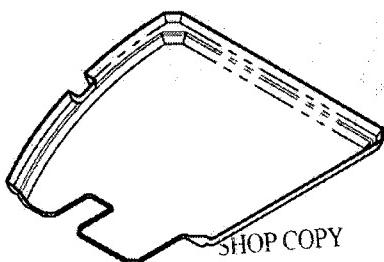
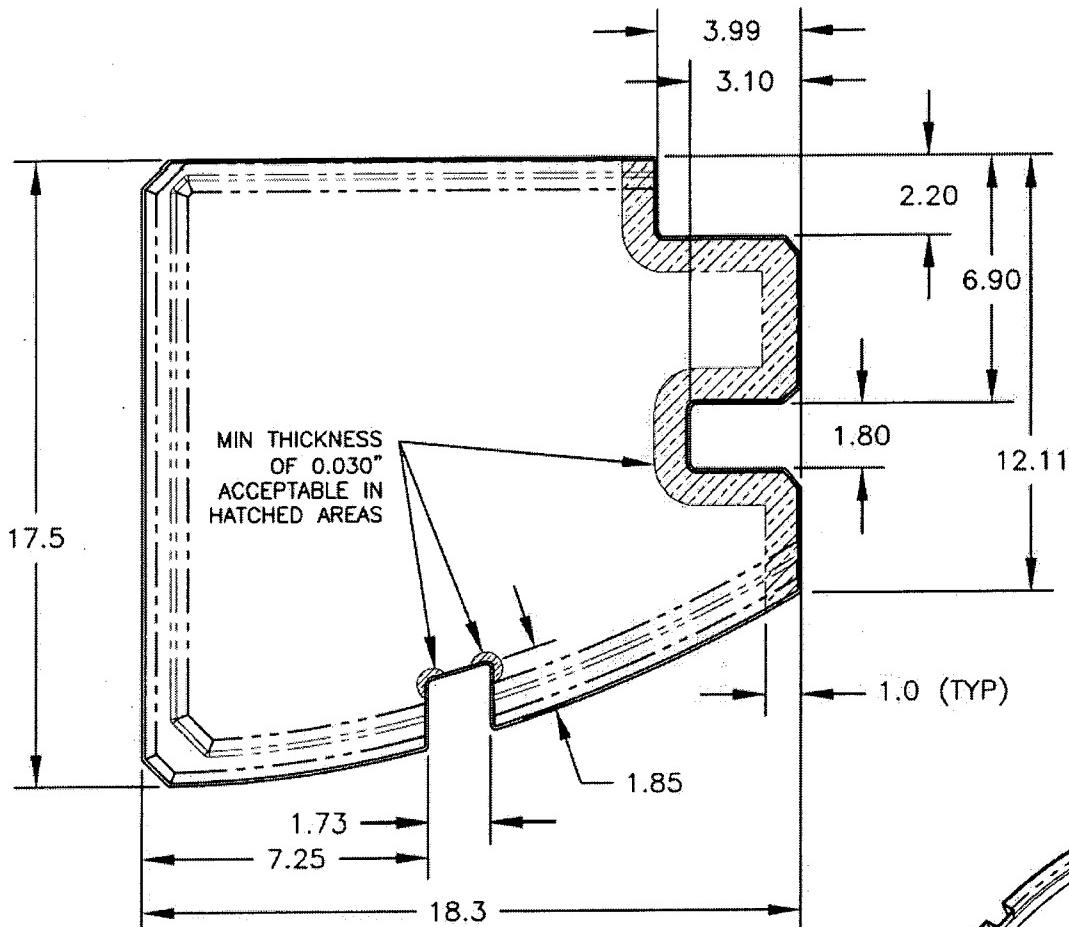
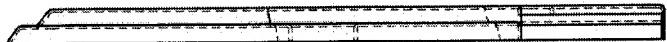
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NO. 26356

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CHECKED <i>AA</i>	APPROVED <i>CH</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.12.01 *CH***D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

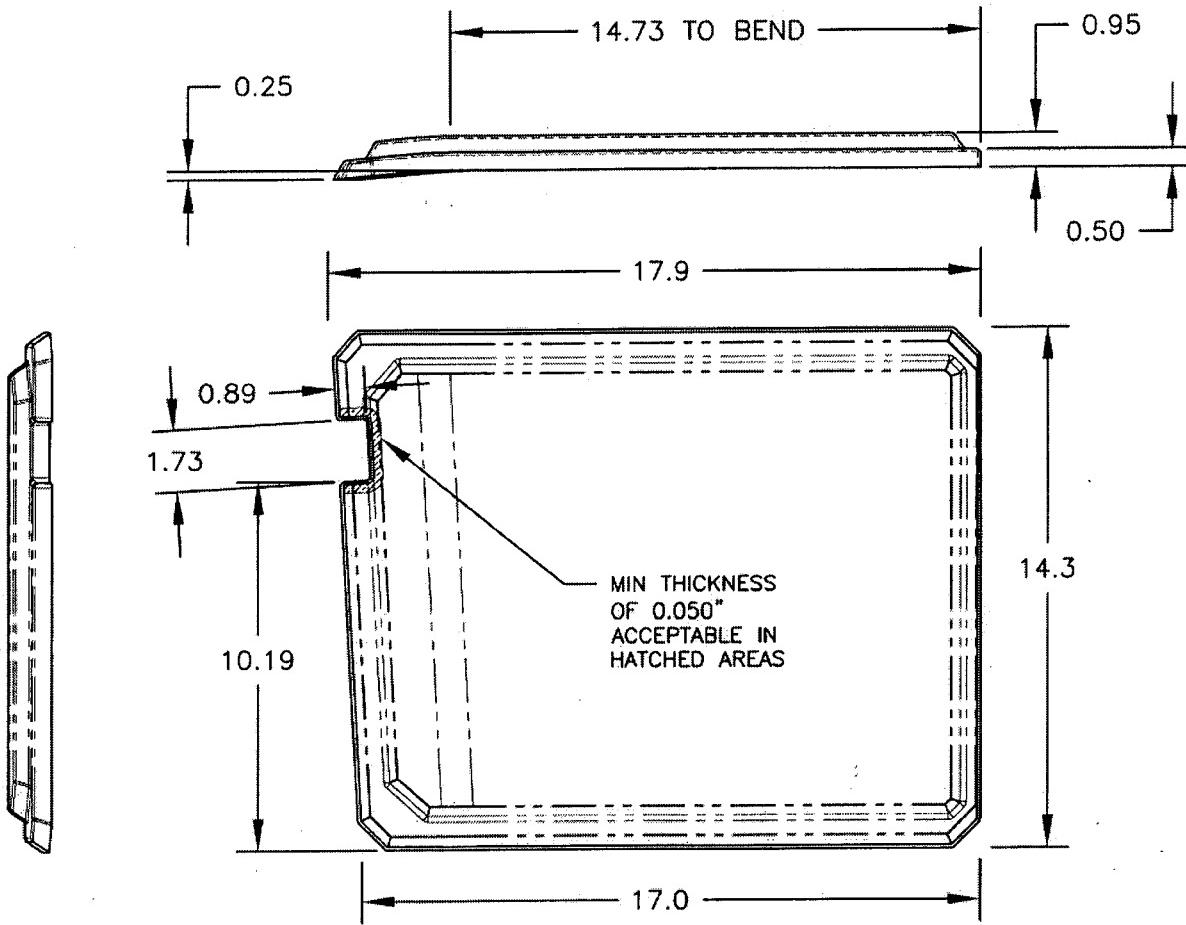
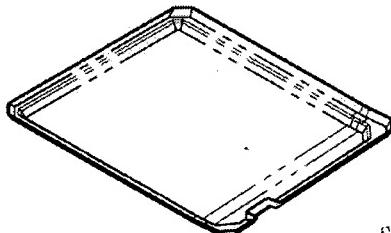
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DART

DESIGN <i>OP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B	SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5	

**RELEASED**
05.12.01**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)****D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2 **NONCONTROLLED COPY**
 - 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN
- SHOP COPY**
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Date: Jeudi, 2006-03-30 08:33:55
Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR AFT, LH
Numéro Job : 34176		Numéro Article : DKC134-0047
Numéro Soumission : 2386		Numéro Dessin : D3281
Numéro B.A. :		Projet Numéro : DKC134
Cette fois : 2006-03-30	No. B.V. :	Révision dessin : B
Prsht Rev. : NC		Matériel : F6006
Prem. fois : -	Type :	Date Due : 2006-04-07
Job précédente : 32266		Qté: 20 UdM: UNITE
Écrit par :		
Vérifié & Approuvé par :		
Commentaires : N° de pièce: D3281-4		
		Process Sheet Rév.: 00

Produit additionnel

Numéro Job:	
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# Séq.:	Machine ou Opération:	Description:
1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
	Commentair Qty.: 0.167 UNITE(s)/Unit T	API.0016
	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.	1-5387-1
	N° de Lot: _____	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
2.0	SÉCHAGE/ANEAL	# Bon achat: 5327 SÉCHAGE / ANEALING

Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 4931

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 21 Date: 11-4-06 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 34176

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
4.0	THERMOFORMAGE2	THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs

THERMOFORMAGE DES PIECES

Faire le thermoformage du "Floor Protector" N° D3281-4 à l'aide du moule N° D3281-4T1 sur le thermoformeur 4' x 8'.

F.O: 11Aurifox
DELASTEK
COMPOSITE
QA-3

Autocontrôle du lot de pièce thermoformées.

Quantité: 21 Date: 15-4-06 Sceau: SR

Quantité: _____ Date: _____ Sceau: _____

5.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs

TRIMAGE PLASTIQUE DART

First stuff retardé
Meeting

NS
DELASTEK
COMPOSITE
QA-3

12Aurifox

Faire le trimage du "Floor Protector" N° D3281-4 à l'aide du gabarit de trimage N° D3281-4T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 21 Date: 17-4-06 Sceau: JC

Quantité: _____ Date: _____ Sceau: _____

6.0	INSPECTION 3	INSPECTION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 21 Date: 13Aurifox Sceau:



7.0	IDENTIFICATION4	IDENTIFICATION PIÈCES DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 34176

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
	N° de pièce: D3281-4 N° de Job: _____ Date de fabrication: _____ Sceau d'inspection.	
	Quantité: <u>20</u> Date: <u>12/4/06</u> Sceau:	
	Quantité: _____ Date: _____ Sceau: _____	
8.0	EMBALLAGE	EMBALLAGE ET ENTREPOSAGE
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs EMBALLAGE ET ENTREPOSAGE Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit: N° de pièce: D3281-4 Date de fabrication: _____ N° de job: _____ Quantité: <u>21</u> Date: <u>13/4/06</u> Sceau:		
	Quantité: _____ Date: _____ Sceau: _____	